

Work Order ID 137580

October 06, 2015 3:50:57 PM

137580

Page 1

Item ID: D117-762-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 10/6/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/27/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: SH Date: 10 15 10 0 Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D117-762	D								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.03							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D117-762-011								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MUS 1571-11

DAS 21 9-89

15/12/19

DAS 6 9-89

NOV 10 2015

DAS 28 9-89

B137991

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																		
Description Work Order Deviation				Disposition																					

~ Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

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Work Order ID: 137580

137580

Parent Item: D117-762-011

D117-762-011

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 10/6/2015

Required Date: 10/27/2015

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A07.06.11New Issue EC
 IPP Rev:B 08-02-22 change to revA DD verified by:ec
 IPP Rev C 08.12.19 incorporated DSI9435 EC verified by:DD
 IPP REV:D 13.11.14 IIN REV.C DD VERF:JLM IPP
 REV:E 15.06.11 IIN REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C4A		Purchased	No				Each	476.0000		8			
AN3C4A									**	133440			DAS 28 9-89
Bolt													

Location	Loc Qty	Loc Code
FG	20	
122814	20	
FP001	111	
M132551	61	
M132803	50	
ST349	152	
M133234	152	
ST350	193	
M132317	193	

NAS1149C0332R

Purchased

No

Each

5,758.000

8

NAS1149C0332R

WASHER

DAS
28
9-89

Location	Loc Qty	Loc Code
FP001	1004	
m132930	1004	
FP01	1871	
m133284	1871	
GA	441	
m133284	441	
ST271	2442	
m133284	2442	

BAS
27
9-89

DAS
6
9-89

8

Picklist Print

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Work Order ID: 137580

137580

Parent Item: D117-762-011

D117-762-011

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 10/6/2015

Required Date: 10/27/2015

Start Qty: 1.00

Required Qty: 1.00

D117-762-041

Manufactured No

110 Each

0.0000

1

1

D117-762-041

Replacement Skidtube

D3512-041

Manufactured No

110 Each

0.0000

2

2

D3512-041

Wearplate

AN6C51A

Purchased No

110 Each

24.0000

2

2

AN6C51A

BOLT

Location

Loc Qty

Loc Code

ST333

24

m133194

24

D3864-1

Manufactured No

110 Each

33.0000

4

4

D3864-1

Bushing

Location

Loc Qty

Loc Code

ST055

33

109111

33

MS21043-6

Purchased No

110 Each

75.0000

2

2

MS21043-6

NUT

Location

Loc Qty

Loc Code

FG

20

103693

20

FP001

17

131618

2

m130325

2

m133077

13

ST304

38

m132164

13

m132234

25

B157991

**

138289

**

**

**

M133483 X1

DAS

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DAS

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DAS

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IIN-D117-762

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5.0 PARTS LIST

REFERENCE ONLY

5.1 D117-762-011 Skidtube Parts List

Item	Qty -011	Qty -041	Part Number	Description
	X		D117-762-011	SKIDTUBE INSTALLATION
	1	X	D117-762-041	REPLACEMENT SKIDTUBE
1		1	D3582-041	SKIDTUBE ASSEMBLY
2	2		**1121-51002	SKID SHOE
3	4		**1121-51102	CLAMPING RING
4	8		**LN9380M8X45	HEXAGON BOLT
5	8		**LN9023A8-1.4544.9	LOCKING WASHER
6	8		**LN9025-0815K	WASHER (OR LN9025-0815L)
10		1	*D2965	CAP
11		2	***AELS-1032-225	INSERT
12		2	*AN3C5A	BOLT
13		2	*AN960C10L	WASHER (OR NAS1149C0332R)
20A		1	*D3508-9	WEARPLATE
20B		1	*D3558-9	GASKET
21A		1	*D3508-3	WEARPLATE
21B		1	*D3558-3	GASKET
22A		1	*D3508-11	WEARPLATE
22B		1	*D3558-11	GASKET
23A		1	*D3508-13	WEARPLATE
23B		1	*D3558-13	GASKET
24		36	*AELS-1032-130	INSERT
25	8	28	*AN3C4A	BOLT
26	8	28	*AN960C10L	WASHER (OR NAS1149C0332R)
27	2		D3512-041	WEARPLATE
30		2	*AELS-1032-130	INSERT
31		2	*AN3C4A	BOLT
32		2	*AN960C10L	WASHER (OR NAS1149C0332R)
40		2	*D3492-049	PLUG ASSEMBLY
41		2	***NAS1611-016	O-RING
42		2	*D3492-051	PLUG ASSEMBLY
43		2	***NAS1611-015	O-RING
44		6	*D3492-053	PLUG ASSEMBLY
45		6	***NAS1611-012	O-RING
50	2		AN6C51A	BOLT
51	4		D3864-1	BUSHING
52	2		MS21043-6	NUT

* PART IS INCLUDED WITH D3582-041 SKIDTUBE ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

*** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: D

Date: 15.03.04